

Date: Friday, 22/05/2009 9:57:10 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PANEL, CENTER POST
Job Number :	48128		
Estimate Number :	13942		
P.O. Number :		Part Number :	D39461
This Issue :	22/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3941-1
First Issue :	22/05/2009	Project Number :	IN0001
Previous Run :		Drawing Revision :	A PROTOTYPE 09.05.21
Written By :		Material :	MLEXS093F600607
Checked & Approved By :	JUD 09.05.22	Due Date :	22/05/2009
Comment :	Est. Rev. A New Issue 09/05/21 DL	Qty:	1 Um: Each

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
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Comment: Qty.: 3.5385 sf(s)/Unit Total: 3.5385 sf(s)
 GE PLASTICS LEXAN SHEET

M107574

09/05/22

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB

09/05/22

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB

09/05/22

(X1)

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3946-1 and folio (FTA 3946-1 Prototype) using tool DT 9483

Dwg. Rev. A

Folio Rev. A

BB

09/05/22

(X1)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB

09/05/22

(X1)

**ENGINEERING
APPROVAL**

Date:

Friday, 22/05/2009 9:57:10 AM

User:

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL, CENTER POST

Job Number: 48128

Part Number: D39461

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



(X1)

Comment: SECOND CHECK

Wh 09.05.22

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



(X1)

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

Wh 09.05.22

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(X1)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

Wh 09.05.22

9.0

QC5

INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**

Comment: INSPECT WORK TO CURRENT STEP

CP 09.05.22

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

FOR ENGINEERING USE ONLY

Identify and Stock

Location: _____

N/A ENG USE ONLY

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Wh 09.05.22

Job Completion



00280A

MF 09-06-01

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D350-766

Job #: 00280A

Date: 09.05.21

Product Name: Interior Trim Kits

Requested By: CP

Design Manager Approval: 

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3946-1	Therm	PANEL	09.05.21	Y	ASAP		
1	D3947-1	Therm	PANEL	09.05.21	Y	ASAP		
1	D3947-2	Therm	PANEL	09.05.21	Y	ASAP		
1	D3947-3	Therm	PANEL	09.05.21	Y	ASAP		
1	D3947-4	Therm	PANEL	09.05.21	Y	ASAP		

DART AEROSPACE LTD	Work Order: 48128
Description:	Part Number: D3946-1
Inspection Dwg: D3946-1 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____" N/A				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: _____

Date: _____

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
38.8"		38.9	✓			
.07"		.175	✓			
2.8"		2.8	✓			
3.2"		3.2	✓			
0.070"		0.074	✓			

Measured by: *JK*

Date: 09.05.22

Audited by: *BB*

Date: 09/05/22

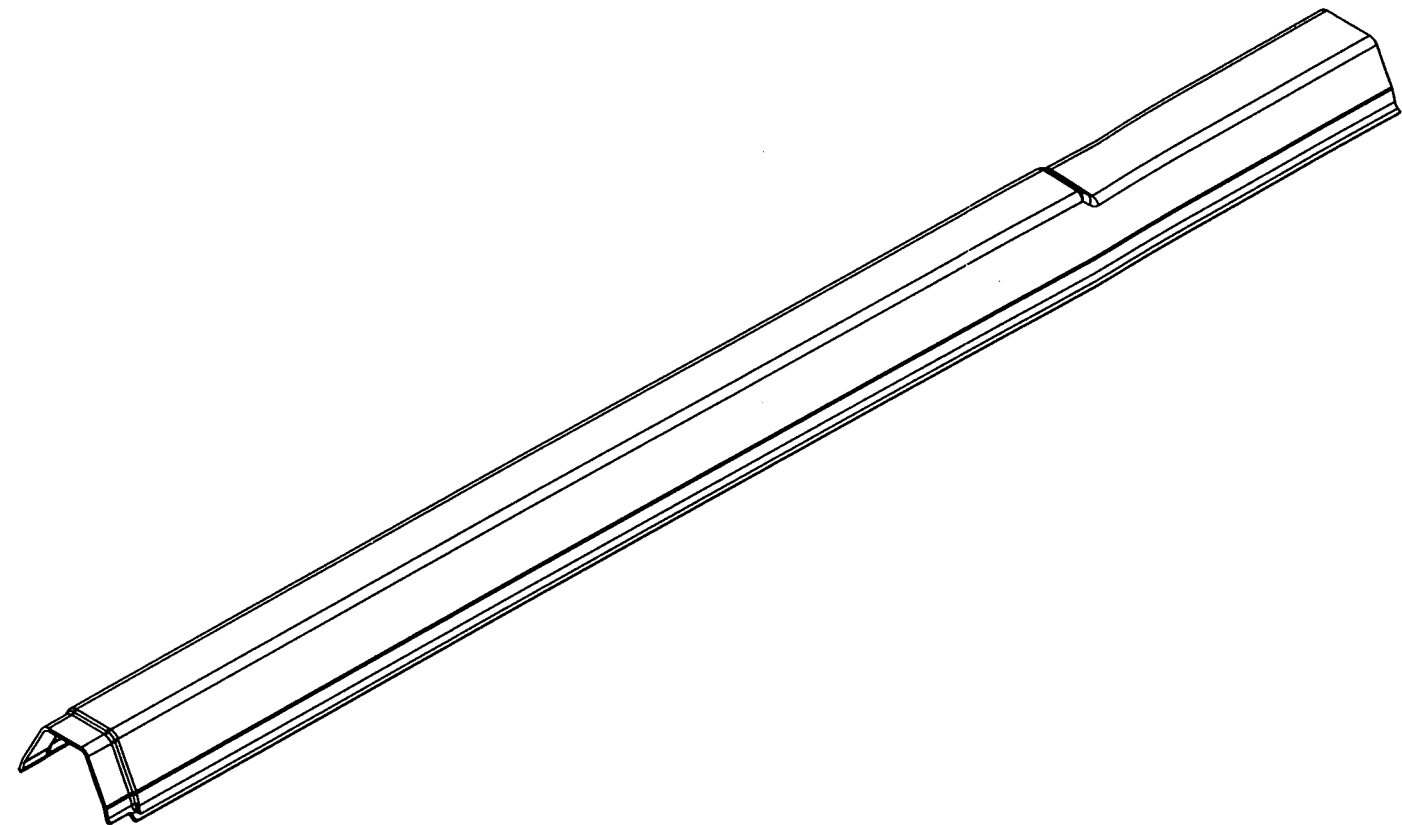
Prototype Approval: *UP*

Date: 09/05/22

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

8 7 6 5 4 3 2 1

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
UP 09.05.21



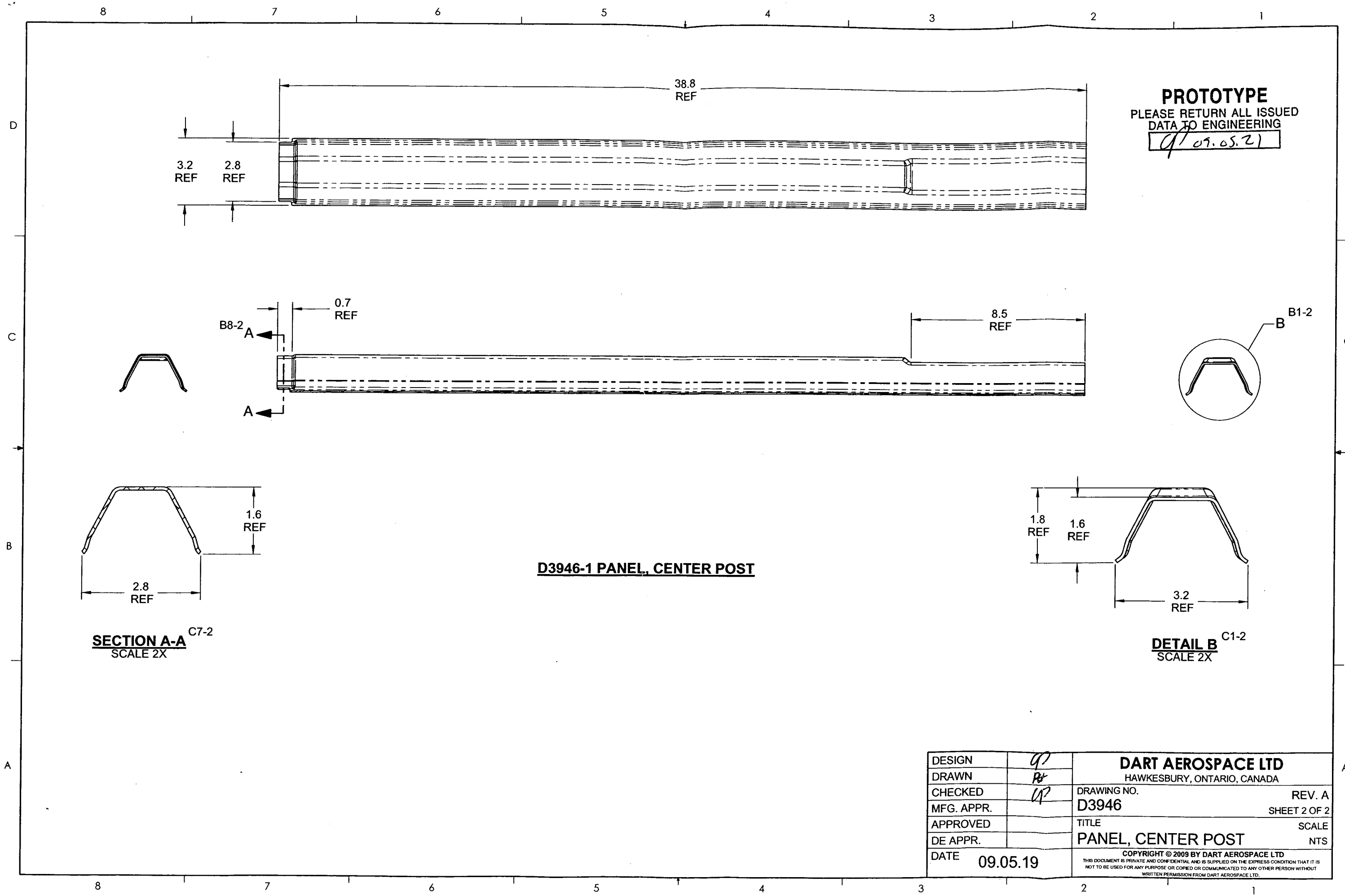
D3946-1 PANEL, CENTER POST

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3946-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.70 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9483 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.070" UNLESS OTHERWISE NOTED

A	NEW ISSUE		PH	09.05.19
REV.	DESCRIPTION		BY	DATE
DESIGN	UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	PH			
CHECKED	UP	DRAWING NO.	REV. A	
MFG. APPR.		D3946	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		PANEL, CENTER POST	NTS	
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8 7 6 5 4 3 2 1



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DRAWN	PR		
CHECKED	GP	DRAWING NO. D3946	REV. A
MFG. APPR.			SHEET 2 OF 2
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